User:

Wednesday, 1/18/2006 4:04:56 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 25556E

Estimate Number

: 10283

P.O. Number

: NIA

: 1/18/2006 This Issue Prsht Rev.

: N/A

: NC

: 25460

Type

S.O. No. : NA

Part Number Drawing Number

Drawing Name

: D31991 : D3199 REV A1

Project Number

Drawing Revision

: N/A : A1

Material **Due Date** :NIA : 2/15/2006

: BRACKET

Qty:

Previous Run Written By

Comment

First Issue

Checked & Approved By

: Est Rev:C

: SPE ABOUR USER & DATE Removed Scribing 05-11-05

COMMENT BELOW

: MACHINED PARTS

JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PURCHASING



Comment: PURCHASING

Issue P/O: 00000450

Email or Ship DXF file to vendor

Laser Cut D3199-1 bracket per Dwg D3199

Material release note is required

2.0

D31991F

Bracket

acholes



Comment: Qty.:

1.0000 Each(s)/Unit Total:

36.0000 Each(s)

Bracket

3.0

PACKAGING 1

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

QC6

DIMENSIONAL CHECK



4.0

5.0

BRAKE NC

Comment: DIMENSIONAL CHECK

NC BRAKE





Comment: NC BRAKE

1-Deburr if necessary SHO 06307520

1-Deburr if necessary 300 USA Already Ferned .



Dart Aerospace Ltd

W /O:		WORK ORDER CHANGES						
DATE	STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector	
								

Part No:	PAR #:	Fault Category:	NCR: Ye	es No DQA:	Date: 🗸	1063/2
			QA	A: N/C Closed:	Date:	

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
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				·						

NOTE: Date & initial all entries

Datas	Wednesday, 1/18/2006 4:04:56 PM		ı
	Kim Johnston	Process Sheet	
Custor	ner: CU-DAR001 Dart Helicopters Services	Drawing Name: BRACKET	_
		P04004	
	ber: 25556E	Part Number: D31991	_
Job Number:			_
Seq. #:	Machine Or Operation:	Description :	_
6.0	QC5	INSPECT WORK TO CURRENT STEP	_ Sa
	mment: INSPECT WORK TO CURRENT		
7.0	POWDER COATING	POWDER COATING	
Coi	mment: POWDER COATING	(4.3.5.6) as per QSI 005 4.3 $DU O(e/0.3/2.0)$ (50)	$\frac{1}{2}$
8.0	Powder Coat Grey Sandtex (Ref:	: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION	4
6.0		INGI EGI FONDEN GONTIANE SONTENIONE SONTENIONE	
Cor	nment: INSPECT POWDER COAT/CHEM		
9.0	PACKAGING 1	PACKAGING RESOURCE #1	
Cor	nment: PACKAGING RESOURCE #1		
	Identify and Stock Location:	(06/3/21 (50)	
10.0	DC	DOCUMENT CONTROL	
Cor	nment: DOCUMENT CONTROL Inspection Level 21	D 06/13/23	
Job Completion	IIISPECION LEVEL 21	N Olev 3.22	
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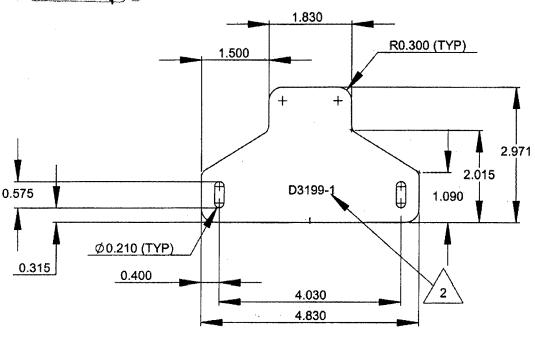
W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					ŧ		
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	
			- QA:	N/C Close	d:	Date:	

NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
		Description of NC	Corrective Action Section B			Manifi andian		Τ
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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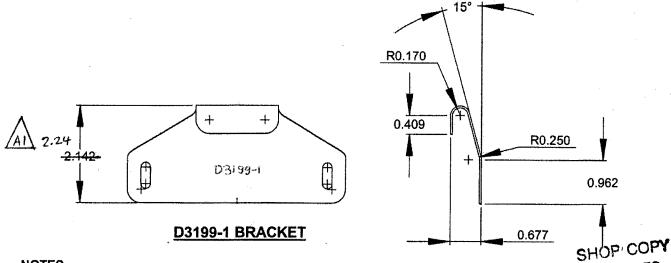
NOTE: Date & initial all entries



DESIGN () DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECK	ED L	APPROVED	DRAWING NO. D3199	REV. A		
DATE	U3 (08.05	TITLE BRACKET	SHEET 1 OF 1 SCALE		
Α		3.08.05	NEW ISSUE	1:2		
Ai		4.03.01 #4	2.24 WAS 2.142			



D3199-1 FLAT PATTERN



1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALEDING 2) SCRIBE DART P/N D3199-1 AS SHOWN.
3) BREAK ALL SHARP EDGES 0.005 TO 0.010

3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

5) ALL DIMENSIONS ARE IN INCHES.

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